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D3914-041
Job Sheet 191378



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/27/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/22/19	0.00	0.00	0.00	Start Up Large Fab-5		
100	Large Fab - Basket - 1	1 pcs	3/22/19	0.00	6.67		Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		12
							Large Fab - 8		
							Large Fab - 9		
106	Large Fab - Basket - 2 - B4B	1 pcs	3/22/19	0.00	6.67		Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		DAS 24
							Large Fab - 7 - B4B		APR 05 2019
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
110	QC 9	1 pcs	3/22/19	0.00	0.00		QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		DAS 24
							QC 9 - 9		APR 05 2019
120	QC 5	1 pcs	3/22/19	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		

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					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	APR 05 2019
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	DAS
					QC 5 - 49	24
					QC 5 - 51	9-89
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
130	Powdercoat - 4 Black Sand - B4B	1 pcs	3/22/19	0.00 0.40	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19-04-11
					Powdercoat - 4 - B4B	
135	QC 3	1 pcs	3/22/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	9/19-4-11
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
140	Handfinish - 3-1- WingWalk-B4B	1 pcs	3/22/19	0.00 0.80	Handfinish - 3 - 1 - B4B	9/19-4-11
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
150	QC 3	1 pcs	3/22/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	

DAS
15
9-89

				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	BEB.
				QC 3 - 6	DAS 59
				QC 3 - 68	
				QC 3 - 9	
160	Packaging 3-1 - Stock - B4B	1	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B

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				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	1 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	APR 11 2019 70
				QC 21 - SA - 53	9-89

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____ - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

106 - (Weld per dwg A/R S.S. rod Batch: _____ - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	
D3914-1	Rib	2 pcs (2 ea)	90-Start up Operation	
D3914-7	Rib	2 pcs (2 ea)	90-Start up Operation	
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	90-Start up Operation	
D4018-5	Rib	9 pcs (9 ea)	90-Start up Operation	
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	90-Start up Operation	
D4021-3	Data Plate	1 pcs (1 ea)	90-Start up Operation	
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	90-Start up Operation	
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5155219
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5163815
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5166787
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	5110937
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	5167541
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	5168996
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5154112
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	5163793

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	73	0
	D3914-1	2	12	0
	D3914-7	2	12	0
	D4016-3	3	126	0
	D4018-5	9	45	0
	D4020-5	1	5	0
	D4021-3	1	21	0
	D4035-043	2	4	0
100-Large Fab - Basket - 1	D2581	2	73	0
	D3914-1	2	12	0
	D3914-7	2	12	0
	D4016-3	3	126	0
	D4018-5	9	45	0
	D4020-5	1	5	0
	D4021-3	1	21	0
	D4035-043	2	4	0

Part Specifications
Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S169851



Part: D3914-041

Job No: 191378

Serial No/Batch: S169851

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/05/19